

Work Order ID 57227

March 30, 2010 11:32:59 AM



Page 1

Item ID: D3571-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 30/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 08/04/2010 Req'd Qty: 10.00



Customer:

Reference:

10-03-30

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3571

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.90" long

DIP 10/03/30

10 *Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA681 Rev: A & Dwg D3571 Rev: A 2-Deburr
per dwg D3571

MMW=
10/04/06

10 *Ø*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MMW=
10/04/06

10 *Ø*

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QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

BA 10/04/07

10 0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> M 10/04/07

(x10) 0



HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3,5,6) per QSI005 4.3

0.00

M112588

M 10/04/07

(x10) 0



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:45pm

OVEN TEMPERATURE:

2:15pm FINISH TIME:

320°F

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Page 3

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-4-8 (10) f

170

Identify as per dwg & Stock Location: 245A

0.00



Packaging

Memo

0.00

Packaging

10/4/9 (10)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/4/12 f
MF 10-4-9

Picklist Print

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Page 1

Work Order ID: 57227

Parent Item: D3571-3

Parent Item Name: Guide

Comments: IPP Rev:A New Issue 07-02-01 JLM
IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Start Date: 30/03/2010

Required Date: 08/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			110	f	6.2559	2.5368			



6061-T6 Bar .750 X 1.50



Warehouse	Loc Qty	Loc Code
Main Warehouse		
MAT02	6.25589949	
110167	6.25589949	

*For 10-03-30
The Batch
only.*

6061-T6 Bar .750 X 1.50 111448

2.5368 (F) DTD

DART AEROSPACE LTD		Work Order:	
Description: Guide		Part Number:	D3571-3
Inspection Dwg: D3571	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

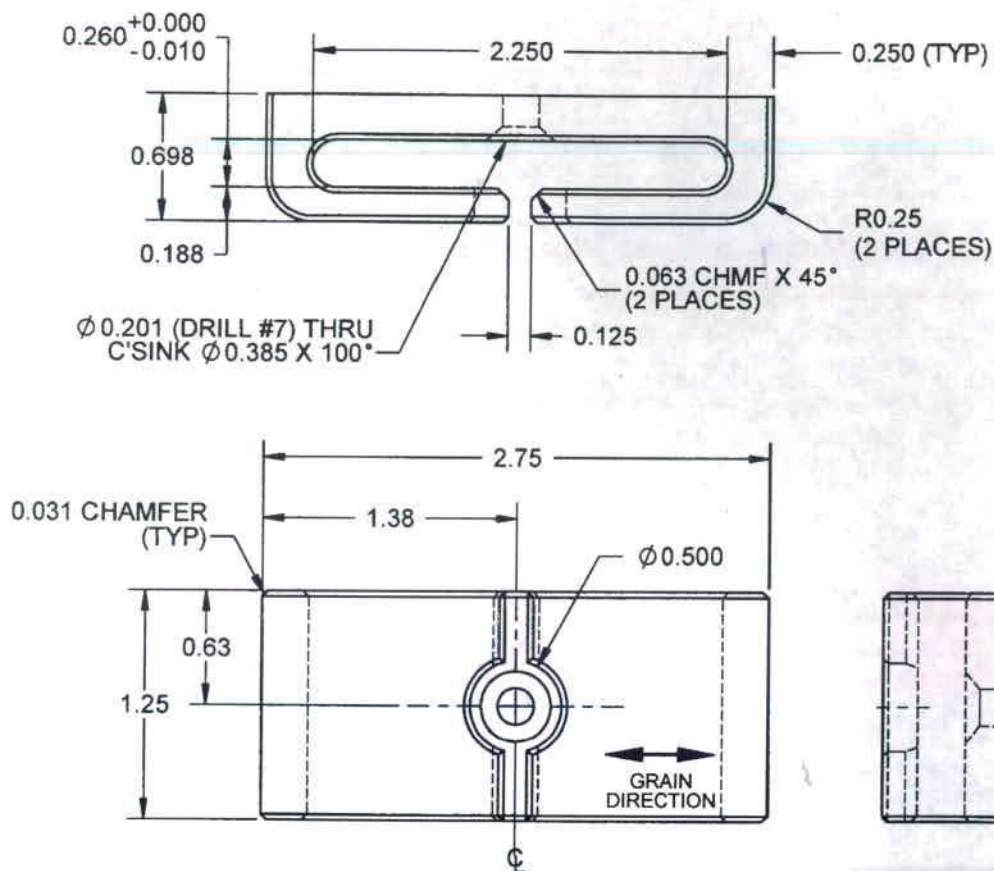
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	✓			
2.75	+/-0.030	2.750	✓			
1.38	+/-0.030	1.38	✓			
1.25	+/-0.030	1.248	✓			
0.63	+/-0.010	.627	✓			
0.031 chamfer	+/-0.010	.031	✓			
Ø0.500	+0.006/-0.001	Ø.500	✓			
Ø0.201	+0.005/-0.001	Ø.203	✓			
R0.25	+/-0.030	R.250	✓			
0.260	+0.000/-0.010	.260	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.389 x 100°	✓			
0.125	+/-0.010	.130	✓			
2.250	+/-0.010	2.242	✓			
0.250	+/-0.010	.249	✓			
0.188	+/-0.010	.189	✓			
0.063 chamfer	+/-0.010	.063	✓			

Measured by: <i>ML</i>	Audited by: <i>B.A</i>	Prototype Approval:	N/A
Date: 10/04/06	Date: 10/04/07	Date:	N/A

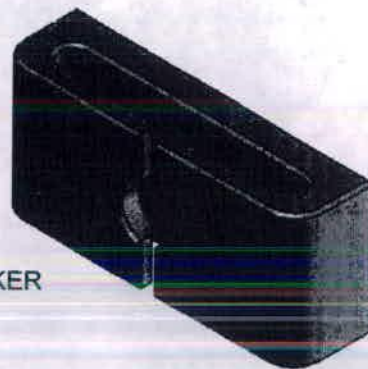
Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29	TITLE GUIDE	SCALE 1:1	

RELEASED07.04.12 *CH***D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

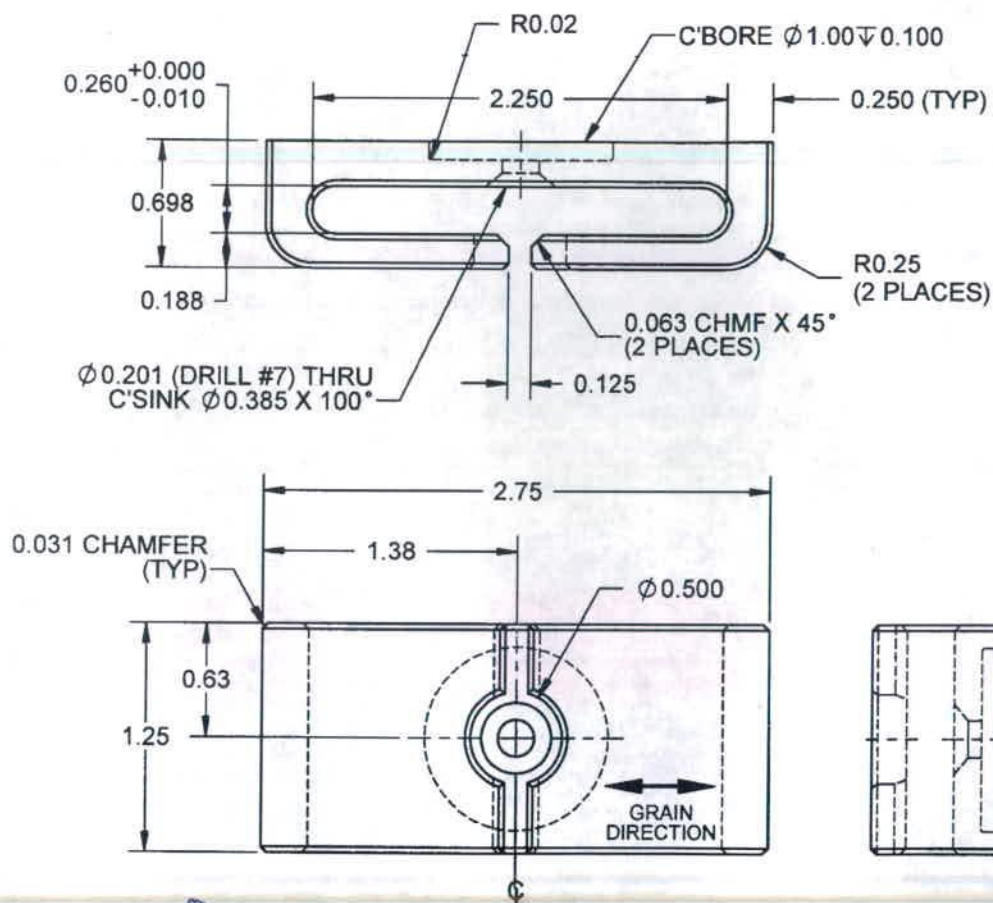


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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE	SCALE 1:1	
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
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- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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